

January 5, 2010 1:51:44 PM

Item ID: Revision ID:

D3706-3

Accept



Setup Start

Stop





Item Name: **Start Date:**

05/01/2010

Guide

Start Qty: 6.00 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Required Date: 15 01/2010

Date: 0-1-05 Tooling:

Run Start



Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ **Work Center ID** Operation Description Set Up/ **Run Hours**

Draw Number Draw Pian Code

Rev.

Accept Qty

Reject Qty

Number

Stamp

Draw Nbr D3706

Revision Nbr

Rev A

100

Conventional Lathe

Lathe Conv

-CONVENTIONAL LATTE 1005an

QC2- Inspect parts off machine FAI/FAIB

Turn as per Dwg D3706

Мето

0.00

0.00

110

QC

.Memo

0.00

0.00

10/01/15

Quality Control

Memo - Mill-as-

0.00

-120-

W/O:	<u> </u>		wc	RK ORDER CHANG	FS					
DATE	STEP	PRO	OCEDURE CHAI		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
								}		
Part No:P		PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA	۸:	Date:		
Resolution:			Disposition	າ:	_ QA: N/C CI	Closed: Date:				
NCR:			WORK ORDI	ER NON-CONFORMA	ANCE (NCF	R)				
DATE	STEP	Description of NC			ion B	Verific	Verification Ap		Approval	
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	gn & Section C		Chief Eng	QC Inspector	
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Insp.



January 5, 2010 1:51:44 PM

Accept Item ID: D3706-3 Setup Start **Revision ID:** Stop Guide Item Name: 05/01/2010 Start Qty: 6.00 **Start Date: Cust Item ID:** Required Date: 15/01/2010 Req'd Qty: 6.00 **Customer:** Reference: Start Run Process Plan: Date: Tooling: Date: Approvals: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Draw Reject Set Up/ Draw Pian Accept Reject Number Rev. Code Qty Qty Number Stamp **Work Center ID** Description **Run Hours** OC2-Inspect parts off machine FAHFAIB Memo 0.00 140 OC8- Inspect parts - second check 0.00 QC Memo Quality Control

150

0.00

Packaging

Memo

Identify as per dwg & Stock Location

0.00

Packaging

10-1-15 60 54

									
	79.6	W	ORK ORDER CHANG	iES					
STEP	PRO	CEDURE CHA	NGE	Ву	D	ate	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
•	PΔR #·	Fault Cate	adory.	NCB: V	as No	DOA	•	Date:	
	V	VORK ORD	ER NON-CONFORM	ANCE (N	CR)				
CTED	Description of NC			VARITI		cation Approval	Approval		
SIEP	Section A	Initial Action Descrip Chief Eng Chief Eng			n &	Section C		Chief Eng	QC Inspector
		:PAR #: Resolution:V	PAR #: Fault Cate Resolution: Disposition WORK ORD STEP Description of NC Section A	STEP PROCEDURE CHANGE PAR #: Fault Category: Resolution: Disposition: WORK ORDER NON-CONFORM STEP Description of NC Section A Corrective Action Section A Corrective Action Description	PAR #: Fault Category: NCR: Ye Resolution: Disposition: QA: N/C WORK ORDER NON-CONFORMANCE (NOTED TO BEST OF CONFORMANCE) STEP Description of NC Section A Section B Initial Action Description Sig	STEP PROCEDURE CHANGE By D :PAR #:Fault Category:NCR: Yes No Resolution:Disposition:QA: N/C Close WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	STEP PROCEDURE CHANGE By Date :PAR #:Fault Category: NCR: Yes No DQA Resolution:Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	STEP PROCEDURE CHANGE By Date Qty	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr :PAR #: Fault Category: NCR: Yes No DQA: Date: Resolution: Disposition: QA: N/C Closed: Date: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A

Work Order ID 55051

Page 3

January 5, 2010 1:51:44 PM

Item ID:

D3706-3

Accept



Setup Start

Revision ID:

Guide Item Name:

Start Late: 05/01/2010

Required Date: 15/01/2010

Start Qty: 6.00

Rea'd Oty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

0.00

0.00

Date:

Run Start



Date:

SPC (Y/N):

Date:

Stop

Sequence ID/

Work Center ID

160

Quality Control

Operation Description

QC21- Final Inspection - Work Order Release

Memo

Set Up/ **Run Hours**

Draw Number Draw Plan Rev. Code

Accept Qty

Reject Qty

Reject Number

Stamp

W/O:			WORK ORDER CHANGES								
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No: PAR #:		PAR #:	Fault Cate	gory:	NCR: Yes No DQA: Date:						
Resolution:			Disposition	1:	_ QA: N/C C	losed:		Date: _			
NCR:			WORK ORDI	ER NON-CONFORMA	ANCE (NC	₹)					
DATE	STEP	Description of NC Section A	Corrective Action Initial Action Descripti Chief Eng Chief Eng		ion B Sign o	Verific Section		Approval Chief Eng	Approval QC Inspecto		
				Office Ling							
											
	1										

Picklist Print

January 5, 2010 1:51:48 PM

Work Order ID: 55051

Parent Item:

D3706-3

Parent Item Name: Guide



Start Date: 05/01/2010 Start Qty: 6.00

Required Date: 15/01/2010

Required Qty: 6.00

Comments: Comment Item ID/

Replacement Mfg/ Item ID Purch Bin Primary Item Location #Last : Cocation

Route Seq ID Unit of Qty on Measure Hand

Remaining Qty To Pick Issued Date Issued

Status

Page 1

M6061T6R0.500

Item & ame

Purchased

28.6070

2.5800

6061-T6 Round Bar .500"

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

28.607

110532 24 4.607 111448

2.58 SL 10/01/15

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	By Date		Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
5.455		STEP Description of NC Section A		Corrective Action Section B				Approval			
DATE	SIEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	QC Inspector			
						1					

DART AEROSPACE LTD	Work Order:	55051
Description: Guide	Part Number:	D3706-3
Inspection Dwg: D3706 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x	First Article	Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.50	0.030	.499	//			
0.450	+/-0.010	H50	1			
3.38	+/-0.030	3.382				
0.03 x 45°	+/-0.030 x +/-0.5°	03x45°	//			
5.25	+/-0.030	5.251				
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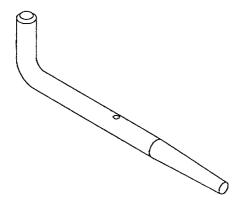
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Measured by:	اد	Audited by:	DIL	Prototype Approval:	N/A
Date:	10/01/15	Date:	10/01/15	Date:	N/A

Rev	Date	Change	Revised, by	Approved
Α	09.05.15	New Issue	KJ 942	- 1

W/O: WORK ORDER CHANGE											
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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DAIL	SIEP	STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng		n & ate	Section C		Chief Eng	QC Inspector	
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D3706-1 LOCK BRACKET

D3706-3 GUNDE



D3706-5 PIN

SHOP COPY RETURN TO **ENGINEERING UNCONTROLLED COF** SUBJECT TO AMENUMENT

WITHOUT NOTICE

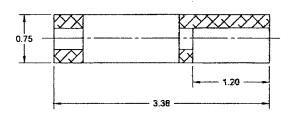
WORK ORDER NO. 55051 B-110-1-05

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REV.			ε	DESCRIPTION	BY	DATE		
DESIGN			DART AEROSPACE LTD					
DRAWN 5		15		HAWKESBURY, ONTARIO, CANADA				
CHECKED A		Pa		DRAWING NO.				
MFG. APPR.		Chrol	↑ D3706			SHEET 1 OF 4		
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DATE 08.05.26				THE COOLINET AND THE COOLINE BY CARTY STUDIES OF CLATS THE COOLINET AS WHATE AND CONTROL WHO IS WHATE AND THE CONTROL OF THE THE CONTROL OF THE ART TO BE WEST OFF THE PRINT OF THE ART TO BE WEST OFF THE PRINT OFF THE ART T				

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Part No	:	PAR #:	Fault Ca	tegory:	NCR: \	res N	o <b>DQ</b>	<b>A</b> :	Date:	
	R	lesolution:	Disposit	ion:	QA: N/	C Clos	sed:		Date:	
NCR:		WC	ORK OR	DER NON-CONFORMA	NCE (N	NCR)				
DATE	CTED	Description of NC					Verific	cation	Approval	Approval
DATE	SIEP									QC Inspector
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0.4% 1.500 4 R0.06 2 PL 0.80 R0.156 TYP



SECTION A-A

#### **D3706-1 LOCK BRACKET**

D3706-1 NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T651)-T6510/-T6511/-T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B) 2) FINISH: NONE

6

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A 7) WEIGHT: 0.17 lbs

0.334 1.15 0.745 R0.156 TYP, 0.375 -1.20 DEEP

Ø0.328 THRU

R0.13

TYP

55051 DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. A D3706 MFG. APPR. SHEET 2 OF 4 TITLE APPROVED SCALE INSTRUMENT PANEL LOCK DE APPR. DATE COPYRIGHT @ 2006 BY DART REROSPACE LTD
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	R	esolution:	Disposition	n:	QA: N/C Clo	sed:	Date: _	
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		Description of NC		Corrective Action Section	n B	Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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0.03 X 45° 3.38 TYP Ø0.50 -0.450 5.25

D3706-3 GUIDE

D3706-3 GUIDE NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6R0.500) 2) FINISH: NONE

6

2) HINISH: NUNE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.10 lbs

55051 DESIGN DART AEROSPACE LTD DRAWN HAVIKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. A D3706 MFG. APPR. SHEET 3 OF 4 APPROVED TITLE SCALE INSTRUMENT PANEL LOCK DE APPR. NTS COPYRIGHT 6: 2009 BY DART AEROSPACE LTD
THE COCUMENT IS REMAIN AND COMMENTATION OF CHRISTING MALT OR
NOT TO BE USED FOR MAY PURPOSE OF COMMENTATION OF MAY COMPLETE OR MAY COMPLETE ON MAY COM DATE 08.05.26

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W/O:		WORK ORDER CHANGES					
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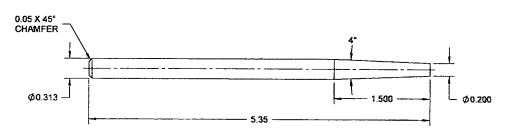
Part No:		PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B		Verification	Approval Chief Eng	Approval QC Inspector			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C					
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© .094 THRU - 2.375 -

1.25 R0.13

D3706-5 PIN (MAKE FROM D3706-5F)



**D3706-5F PIN** 

D3706-5 NOTES:

1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR (REF. DART SPEC. M303R)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 0.11 lbs

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DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA D3706 CHECKED DRAWING NO. REV. A MFG. APPR. SHEET 4 OF 4 APPROVED SCALE INSTRUMENT PANEL LOCK DE APPR. THE DOCUMENT AND DESCRIPTION OF THE DOCUMENT AND DESCRIPTION OF THE DOCUMENT OF THE DOCUMENT AND DESCRIPTION OF THE DOCUMENT OF THE DOCUMENT AND DESCRIPTION OF COMMAND TO THE DESCRIPTION OF THE DOCUMENT AND DESCRIPTION OF DATE 08.05.26 3

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	F	lesolution:	Disposition:	QA: N/	C Closed: _		Date: _	<del>. ,</del>

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